



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

20NR-04-1
Job Sheet 171545



Part No: 20NR-04-1

Job Qty: 4 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 20NR-04 Rev 6 IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/13/18	0.00	0.00	Start Up Machining-4		J.C. - L
100	Mill Conv	4 pcs		2/14/18	0.50	0.80	Mill Conv 2		J.C. - L
110	QC	4 pcs		2/14/18	0.00	0.00	QC2 Machining-5		J.C. - L 18-02-08
120	QC	4 pcs		2/14/18	0.00	0.00	QC8 Machining-5		J.C. - L 18-02-13
130	Packaging	4 pcs		2/14/18	0.00	0.00	Packaging3-2		DAS SRL
140	QC21-SA	4 Ea		2/14/18	0.00	0.00	QC21		21 FEB 15 2018

Part Op 100 - 1-Drill hole in shaft. Shaft should be retracted when drilled. Studs facing you rotate shaft clockwise to the end of the stroke, push shaft into solenoid then drill as per DWG sheet 2 2-Engrave S/N and/or P/N number using Marktronic engraver as per DWG.
130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
H-1127-020P	TBD	4 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	H-1127-020P	4	4	0

Part Specifications

Specifications could not be found.

Plex 2/2/18 1:17 PM Dart.lajeunesse.marie

DART
AEROSPACE
S040265



Solenoid

Dart Aerospace Ltd.

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CANADA

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PART NO: 20NR-04-1

Original Serial #: S040265

Revision:

Operation:

Change No:

Start up Operation 02/07/18

Job No: 171545

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

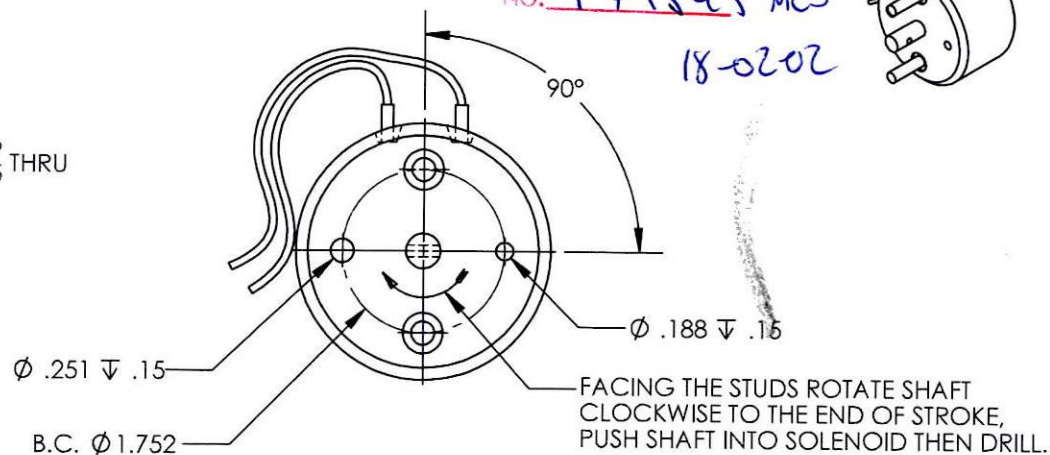
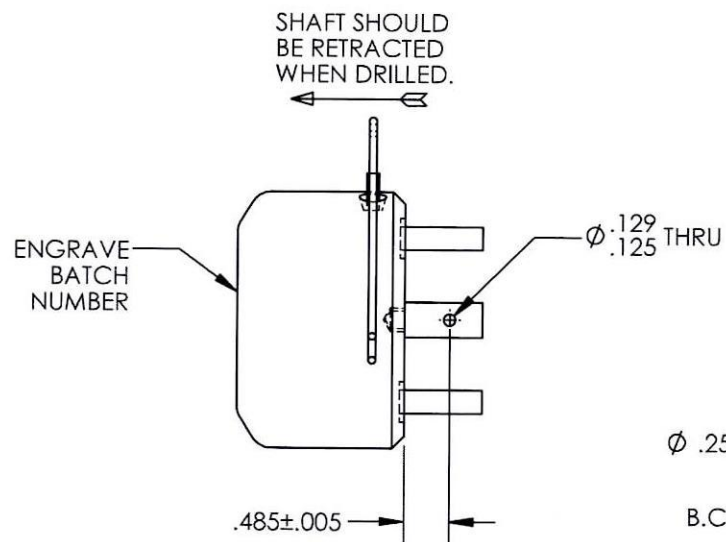
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

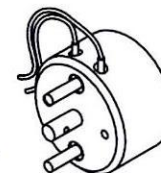
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	14-0206	20NR-04-1 ADDED ENGRAVE BATCH # NOTE.	11/3/2014	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171545 M05

18-0202



(20NR-04-1)

SOLENOID

DART AEROSPACE	
TITLE SOLENOID	
DWG NO. 20NR-04-1	REV 6
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .005$.XX $\pm .01$.X $\pm .1$ FRACTIONS $\pm 1/8$ ANGLES $\pm 5^\circ$	DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/1/1995
SHEET 2 OF 3	